

Date: Thursday, 20/11/2008 3:34:07 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 43599		Part Number	: D2746	
Estimate Number	: 10330		Drawing Number	: D2746 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 20/11/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 20/12/2008 Qty: 12 Um: Each	
Previous Run	: 41737				
Written By	:				
Checked & Approved By	: <u>JUL 08.11.21</u>				
Comment	: Est Rev: D 02.10.24 Re-format KJ Est Rev: E 06-03-21 as Per Rev C JLM Est Rev: F 06-06-12 Now On Waterjet JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1010S20GA	1010/1025 SHEET
		Comment: Qty.: 0.4263 sf(s)/Unit Total : 5.1156 sf(s) 1010/1025/A21/6aA .040" SHEET (M1010S20GA) Batch: <u>109289</u> <u>IB 8-12-10</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2746 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>IB 8-12-10</u>
		2-Deburr if necessary <u>IB 8-12-10</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-12-10</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>Done cut step #2-2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARSHOE

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326
2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746

JB 88/12/15

13

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

88/12/15 (X13)

8.0 POWDER COATING

POWDER COATING



M 109648

1.3X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1-50

OVEN TEMPERATURE: 320°

FINISH TIME: 2-20

m-1 08/12/15

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/12/15

13

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST496

88 08/12/16 (13)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 JJ

Job Completion



08/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43599
Description: Wearshoe	Part Number:	D2746
Inspection Dwg: D2746	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

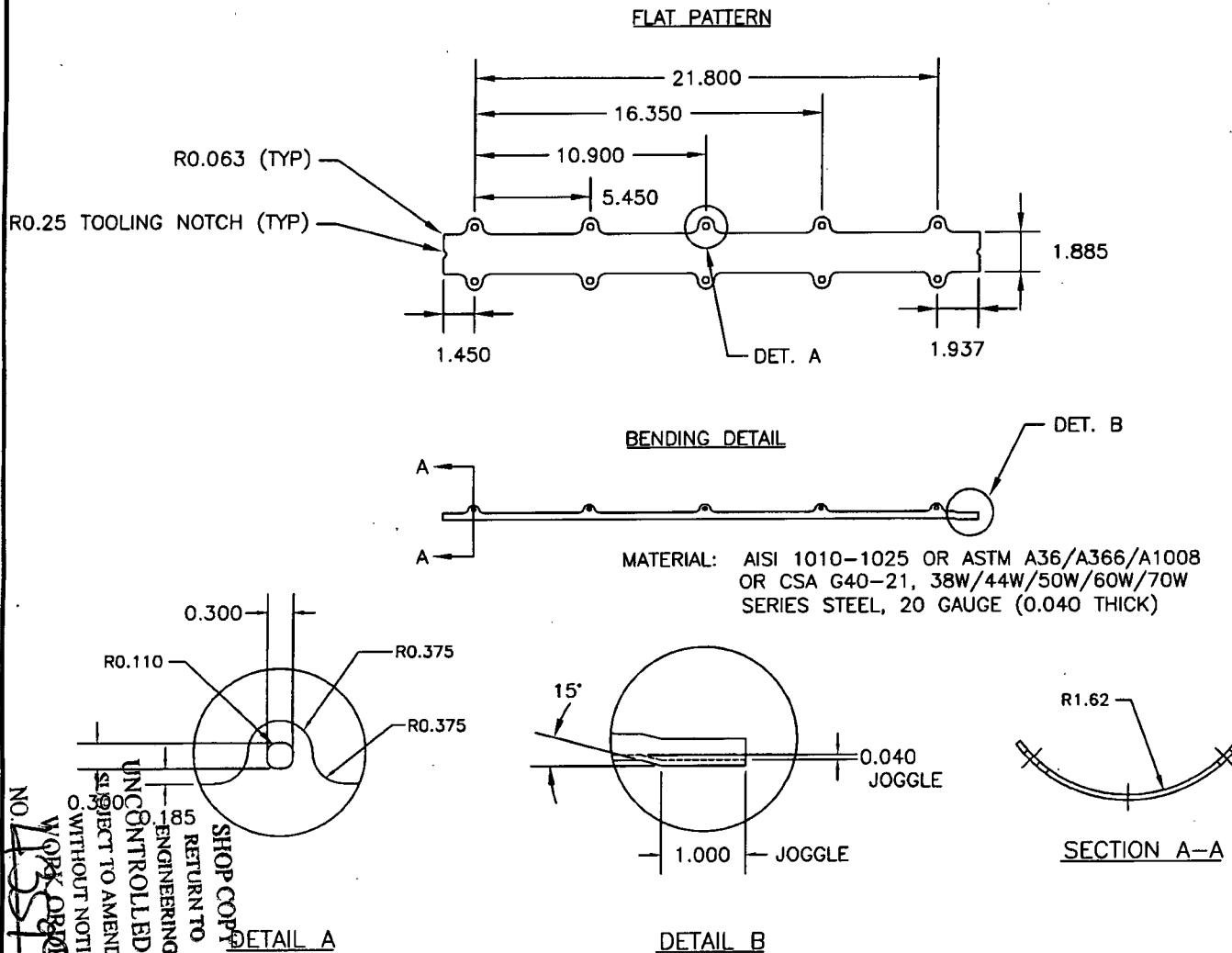
X First Article Prototype

Measured by: <u>AB</u>	Audited by: <u>CD</u>	Prototype Approval: N/A
Date: 8-12-10	Date: 6/12/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	EE

DART**RELEASED**
06-07-07

DESIGN *FH* DRAWN BY *FH* DART AEROSPACE USA, INC.
CHECKED *MM* APPROVED *MM* PORT HADLOCK, WA
DATE 06.01.12 DRAWING NO. D2746 REV. C
TITLE WEARSHOE SHEET 1 OF 1
SCALE 1:8



NO. 4389
WORK ORDER
NOTES
185 RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21